

534

DART AEROSPACE LTD		Work Order:	23920
Description: 206 A/B High Gear Web		Part Number:	D2654-3
05.01.13 E1 05.01.13			
Drawing: D2654 Rev. 2 DEO 9136		Qty:	11 8 10 11 5/08/17

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	AP	05/08/03	8/10
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-5 Web B12433	DP	05-8-22	10
3	METAL	Cut D2600-5 to length as per Dwg D2654	DP	05-8-22	10
4	METAL	Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	PmC	05-8-30	10
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	PmC	05-8-30	10
6	METAL	Deburr holes and ends	PmC	05-8-30	11
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	PmC	05-8-31	11
8	QC	Inspect Level 5	Z	05-09-07	11
9	METAL	Identify and stock	PmC	05-9-7	11
10	EXPEDITING	Close Work Order Inspect level 21 Cost/part: 17.76 Sur 05/08/08 (11) 27.07	PmC	05-9-18	11

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	02-05-27

RELEASED


02/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

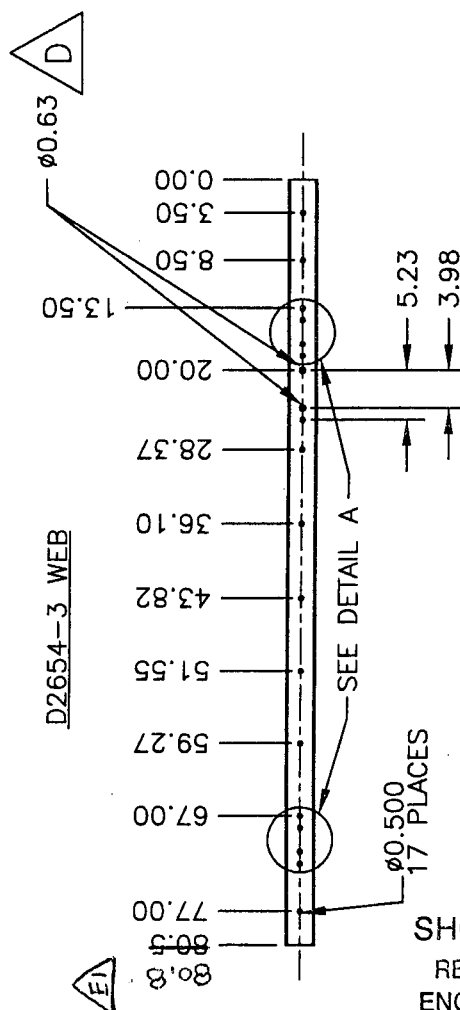
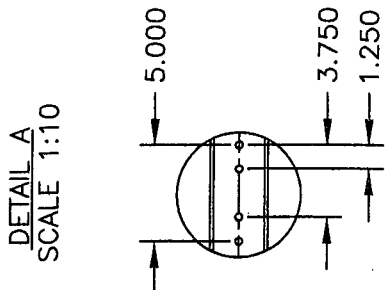
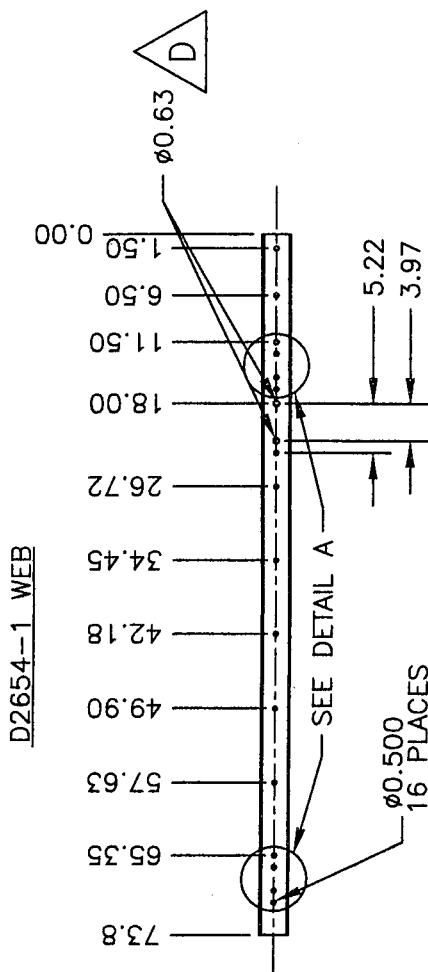
NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 05/09/08
QA: N/C Closed: _____ Date: _____



DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE			TITLE		
04.05.26			WEB		
			SCALE		
			1:20		
A	97.03.25			NEW ISSUE	
B	97.06.26			ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29			CHANGED HOLE PATTERN	
D	98.01.15			GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26			CHANGE LENGTHS, REFORMAT	
E1		04.08.04		PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



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WITHOUT NOTICE

WORK ORDER

NO. 23920

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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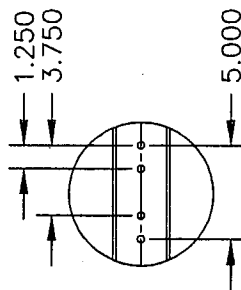
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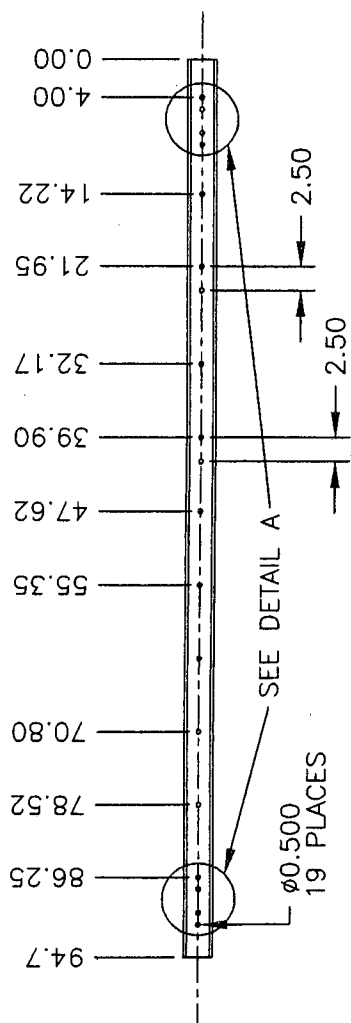
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED
04.06.22

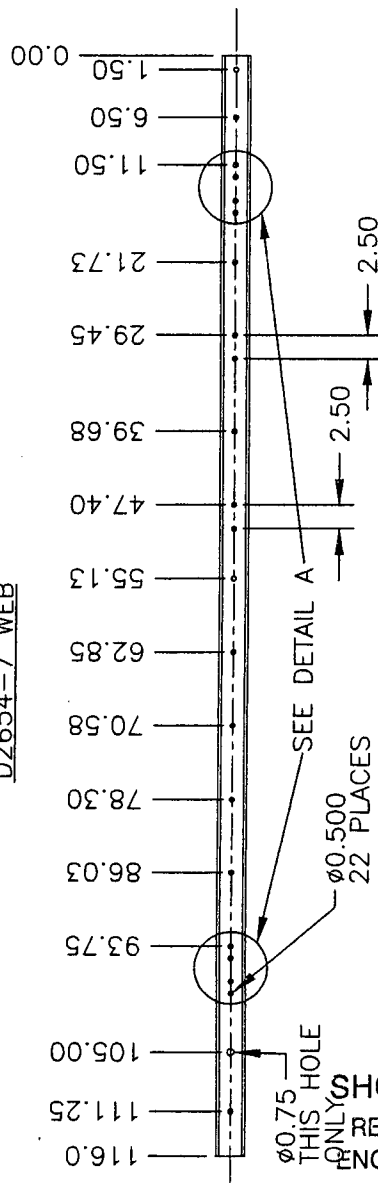
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.75 —
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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	:	0023920	Department Code:	
Project Name	:	D2654-3	Burden Flags	: NNNNNNNN
Project For	:	WK534	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2654-3	Invoice Number	:
Description	:	206 I-Beam (Web)	Invoice Amount	: 0.00
Manufactured	:	Yes	Order Entry No	:
Amount Req'd	:	8	OE Value	: 0.00
Amount Done	:	0	Est Margin	: 0.000%
Start Date	:	08-02-05	Actual Margin	: 0.000%
Est Finish Date	:	08-31-05		
Act Finish Date	:			
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00